

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000164**Date Inspected:** 29-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification**
Mechanical Testing, describe: side bend, reduced section
tension and macroetch
specimens.**Index Lot #:** B71-014-07a**Witness Lot #:** B49-019-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhang Xing Jin/SAW; Jiang Xiao Hu/FCAW **WID #:**

N/A

Joint Description: B-U2a-GF

N/A

WPS ID #: PWPS-B-T-223(2)1T-1

N/A

Base Metal: A709-Gr 50-2/Z25

N/A

PQR ID #: HP200712

N/A

Thickness: 60 mm

N/A

Process: FCAW + SAW

N/A

Electrode Spec/Class: See Below

N/A

Positions: 1-G

N/A

Backing Material: A709MCeramic JN 401

N/A

CWI: Liu Liu and Huang Wei

N/A

Average Amps:

N/A

AWS Code: AWS D1.5 (2002)

N/A

Average Volts:

N/A

Applicable Sec: AWS 5.13

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

: Caltrans Quality Assurance (QA) Inspector was present as requested by ZPMC Quality Assurance Manager, Mr. Lui Lui to witness the mechanical testing for procedure qualification (PQR) testing of HP200712. The PQR test plate was welded in the 1G position using the flux core arc welding (FCAW) and submerged arc welding (SAW) process. The welding consumable for the FCAW root and three filler pass welds is identified as a 1.4mm diameter electrode, AWS specification A5.20 and classification E71T1. The SAW welding consumable is identified as a 4.8mm electrode, AWS specification A5.17, classification EH14 and S-777MXH (F7A(P)2) type flux. The mechanical testing was performed in accordance with AWS D1.5 section 5.13, figure 5.3 requirements. The weld test specimens appeared to comply with the contract documents.

Summary of Conversations:

At 0900 hours. ZPMC Quality Control Inspector, Mr. Hu Gang met with Caltrans QA and stated that ZPMC would be performing mechanical for PQR HP200712 at 0930 hours. At 0930 hours Caltrans was present to witness the mechanical testing.

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is in general conformance with the contract requirements.

Observed welding,testing or results:

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Hasler,Mike

Quality Assurance Inspector

Reviewed By: McClary,David

QA Reviewer